

Work Order ID 74075

Wednesday, September 21, 2011 10:33:06 A



Page 1

Item ID: D4154-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 9/21/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: 11 Date: 11-09-21 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4154	B

100 0.00



Waterjet

Memo

0.00

B 11-9-27

FLOW CNC Waterjet

304 . 050

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

(7)

110 0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

B 11-9-27

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74075

Wednesday, September 21, 2011 10:33:06 A

Page 2

Item ID: D4154-1

Accept

Revision ID:

Item Name: Plate

Start Date: 9/21/2011 Start Qty: 6.00

Required Date: 9/30/2011 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Suloriz

(47)

130

Form as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

SP 11/09/29

(6)

PTD

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Suloriz

(46)

W/O: <u>74075</u>		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4154-1 PAR #: _____ Fault Category: Small FAB / water Jet NCR: Yes No DQA: ✓ Date: 11/11/24
 Resolution: SCAD Disposition: SCAD QA: N/C Closed: ✓ Date: 11/11/24

NCR: <u>11-1013</u>		WORK ORDER NON-CONFORMANCE (NCR) <u>5108</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/09/29</u>	<u>130</u>	<u>1 part missed a tab</u> <u>R.C. moved during water</u> <u>jet it missed @ qc inspectn</u>	<u>[Signature]</u> <u>02/12</u>	<u>Scrap & destroy</u> <u>Qty = 1 No Replace.</u>	<u>11/09/29</u> <u>[Signature]</u>	<u>[Signature]</u> <u>02/12</u>	<u>[Signature]</u> <u>11/09/29</u>	

NOTE: Date & initial all entries

Work Order ID 74075

Wednesday, September 21, 2011 10:33:06 A



Page 3

Item ID: D4154-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 9/21/2011 Start Qty: 6.00 -



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: *W/A*

0.00



Packaging

Memo

0.00

Packaging

EZ 11-11-22 X6

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/23
MF
11-11-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 21, 2011 10:33:12 AM

Page 1

Work Order ID: 74075

Parent Item: D4154-1

Parent Item Name: Plate



Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA

Purchased

No

100

sf

205.5550

4.2697

26.96653

32,



1311 9-27

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

64.655

113062

0.155

116979

64.5

MAT021

140.9

118217

140.9

118217

(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	74025
Description: Plate		Part Number:	D4154-1
Inspection Dwg: D4154 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.400	+/-0.010	.400	2		V B02	
0.450	+/-0.010	.450	2		V	
0.125	+/-0.010	.125	2		V	
0.88	+/-0.030	.88	2		V	
1.19	+/-0.030	1.188	2		V	
5.273	+/-0.010	5.274	2		V	
2.75	+/-0.030	2.75	2		V	
15.80	+/-0.030	15.80	2		T K301	
3.95	+/-0.030	3.953	2		V	
4.00	+/-0.030	3.999	2		V	
6.42	+/-0.030	6.423	2		V	
21.75	+/-0.030	21.75	2		T	
4.35	+/-0.030	4.347	2		V	
1.80	+/-0.030	1.812	2		V	
21.31	+/-0.030	21.31	2		T	
4.26	+/-0.030	4.263	2		V	
8.83	+/-0.030	8.83	2		T	
5.16	+/-0.030	5.16	2		V	
0.55	+/-0.030	.545	2		V	
91.56	+/-0.030	91.56	2		T	
90.41	+/-0.030	90.41	2		T	
74.45	+/-0.030	74.45	2		T	
66.51	+/-0.030	66.51	2		T	
48.59	+/-0.030	48.59	2		T	
40.76	+/-0.030	40.76	2		T	
15.45	+/-0.030	15.45	2		T	
5.223	+/-0.010	5.222	2		T	
Ø0.516	+0.008/-0.001	.516	2		V	
Ø0.188	+0.005/-0.001	.191	2		V	
0.050	+/-0.010	.050	2		V	

Measured by:	B	Audited by:	S	Preliminary Approval:	
Date:	11-9-07	Date:	11/09/07	Date:	

Rev	Date	Change	Revised by	Approved
A	10.09.23	New Issue	KJ	
b	11.04.28	Dimensions updated per Dwg Rev B	KJ	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

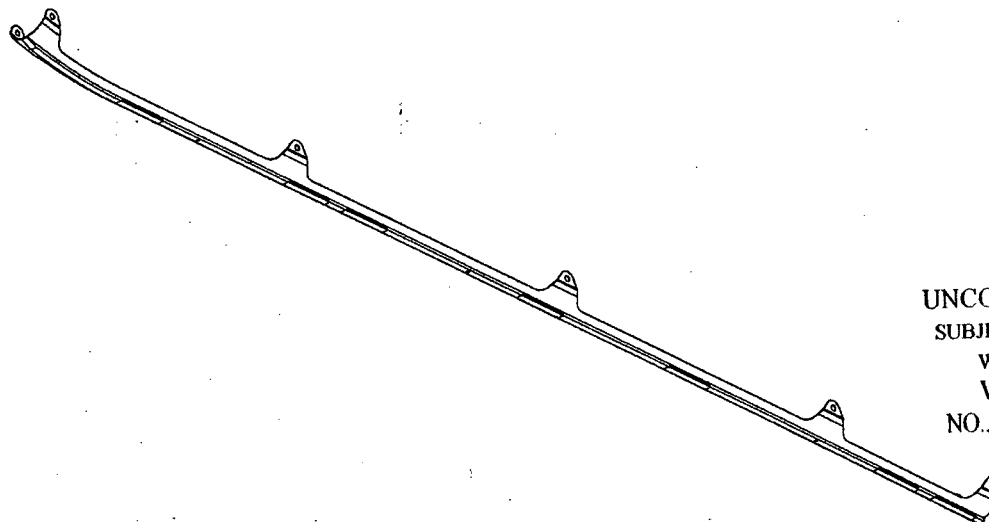
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2)

△B



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74675

11-09-21

D4154-041 WEARPLATE ASSEMBLY

RELEASED
2011-04-13
AM

B	ITEM 4 WAS PR1422 (03-1); REMOVED FINISH TO NOTE 2 (AS-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SE	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	5		
CHECKED	<i>11/4</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AD</i>	D4154	SHEET 1 OF 3
APPROVED	<i>AD</i>	TITLE	SCALE
DE APPR.	<i>AD</i>	WEARPLATE ASSEMBLY	NTS
DATE	11.04.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

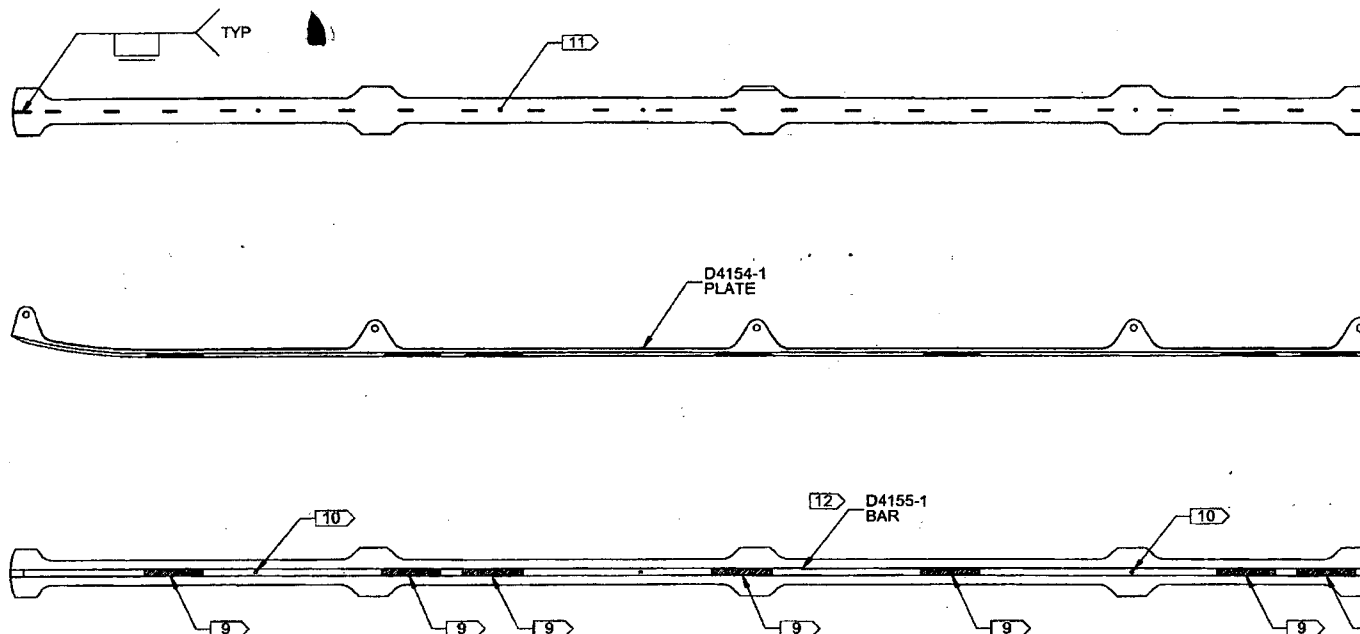
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NOTE: Date & initial all entries



74025

D4154-041 WEARPLATE ASSEMBLY

RELEASED
2011-04-13

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 6.88 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	5	PORT HADLOCK, WA	
CHECKED	4	DRAWING NO.	REV. B
MFG. APPR.	11/05	D4154	SHEET 2 OF 3
APPROVED	11/05	TITLE	SCALE
DE APPR.	11/05	WEARPLATE ASSEMBLY	NTS
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